

Work Order ID 145324

Thursday, May 05, 2016 1:33:02 PM

646.9601  
B145324  
REV. N/C

\*145324\*

Page 1

Item ID: 646.9601

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Upper Cutter Assembly

Start Date: 5/11/2016 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/16/2016 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 06 2016

Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # : Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|-----------------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|-----------------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| 646.9600 | N/C          |

110 Pick Kit 0.00

\*110\*

Packaging

Memo

0.00

Packaging

DAS  
6  
9-89

MAY 25 2016

120 0.00

\*120\*

Small Fab

Memo

1.34

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M134524  
exp. date: 09/17

DAS  
30  
9-89

2

JUN 29 2016

130 QC5- Inspect part completeness to step on W/O 0.00

\*130\*

QC

Memo

0.04

Quality Control

2

DAS  
38  
9-89

JUL 05 2016

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Page 2

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\*N900040100\*

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Stop \*NS2\*

Item Name: Upper Cutter Assembly

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Cust Item ID:

Required Date: 5/16/2016 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

Identify as per dwg & Stock Location

CC1039

0.00

\*140\*

Packaging

Memo

0.02

Packaging

\*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*

2 JUL 05 2016

DAS  
6  
9-29

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.20

Quality Control

16/7/6  
dem 16/07/05

# Picklist Print

Thursday, May 05, 2016 1:33:06 PM

Page 1

Work Order ID: 145324

**\*145324\***

Parent Item: 646.9601

**\*646 9601\***

Parent Item Name: Upper Cutter Assembly

Start Date: 5/11/2016

Required Date: 5/16/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 646.9701                        |                        | Manufactured  | No          |                     |                  | 110             | Each               | 10.0000        | 1           | 2            |               |                |        |

**\*646 9701\***

Cutter Sub Assembly

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| cck012   | 10      |          |
| 141900   | 4       |          |
| 142645   | 3       |          |
| 142646   | 3       |          |

646.9811

Manufactured No

110 Each 10.0000 1 2

**\*646 9811\***

Upper Deflector

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| cck011   | 10      |          |
| 128452   | 10      |          |

MS21042L08

Purchased No

110 Each 1,195.000 3 6

**\*MS21042L 08\***

Nut

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| GA       | 319     |          |
| m133134  | 3       |          |
| m134063  | 316     |          |
| ST303    | 619     |          |
| m129682  | 82      |          |
| m133922  | 37      |          |
| m134574  | 200     |          |
| m134654  | 300     |          |
| ST308    | 257     |          |
| m134376  | 257     |          |

DAS  
6  
9-89

DAS  
6  
9-89

MAY 25 2016

DAS  
6  
9-89  
JUL 05 2016

# Picklist Print

Thursday, May 05, 2016 1:33:06 PM

Page 2

Work Order ID: 145324

**\*145324\***

Parent Item: 646.9601

**\*646 9601\***

Parent Item Name: Upper Cutter Assembly

Start Date: 5/11/2016

Required Date: 5/16/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

526.0000

3

6

**\*MS27039-08-19\***

**\*\***

Screw

DAS  
6  
9-59

Location

Loc Qty

Loc Code

GA

227

m132930

84

m133077

22

m134063

121

over006

100

m134294

100

ST277

199

m134142

199

NAS1149FN832P

Purchased

No

110

Each

2,170.000

6

12

**\*NAS1149FN832P\***

**\*\***

Washer

JUL 05 2016

Location

Loc Qty

Loc Code

GA

475

M133316

16

M133769

459

ST260a

1200

M134257

1200

ST264

495

M133709

495

DAS  
6  
9-59

|                                                                |                                     |                      |                      |                 |                                                                                           |
|----------------------------------------------------------------|-------------------------------------|----------------------|----------------------|-----------------|-------------------------------------------------------------------------------------------|
| <b>APICAL</b><br>INDUSTRIES, INC.                              | ENGINEERING CHANGE NOTICE NO. 02743 |                      |                      | SHEET 1 OF 1    |                                                                                           |
|                                                                | DWG NO. 646.9600                    | REV: N/C             | PREPARED BY S. HUFF  | DATE: 01/07/10  | EFFECT ON DWG<br><input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC. |
|                                                                | DWG TITLE: CUTTER ASSY              |                      |                      |                 |                                                                                           |
|                                                                | APPROVED BY: ENGR <i>P. Brans</i>   | MFG <i>Amel Gony</i> | QC <i>Wendy L...</i> | EFF: NEXT ORDER |                                                                                           |
| TRANSACTION CODES (TC):<br>A-ADD C-CREATE<br>R-REVISE D-DELETE | REASON: REVISED SCREW LENGTH.       |                      |                      |                 |                                                                                           |

STOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 145324 MWS  
 16-05-06

|                                                                                                                                                                                    |    |             |       |       |             |                                                                          |                                                                     |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|-------------|-------|-------|-------------|--------------------------------------------------------------------------|---------------------------------------------------------------------|
| 3                                                                                                                                                                                  | R  | 601.3157    | 3     | 3     | 3           | SCREW                                                                    | MS27039-0818                                                        |
|                                                                                                                                                                                    |    |             | .9603 | .9602 | .9601       |                                                                          |                                                                     |
| F/N                                                                                                                                                                                | TC | PART NUMBER | QTY   |       | DESCRIPTION |                                                                          | MATERIAL/SPECIFICATION                                              |
| DOCUMENTS EFFECTED:                                                                                                                                                                |    |             |       |       |             | CHANGE CATEGORY                                                          | DER REVIEW REQUIRED                                                 |
| <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM |    |             |       |       |             | <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR | <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO |

| REVISIONS |                             |          |          |
|-----------|-----------------------------|----------|----------|
| REV.      | DESCRIPTION                 | DATE     | APPROVER |
|           | LAST PROTOTYPE REVISION PP1 |          | THC      |
| THC       | FINAL RELEASE               | 04/30/97 | P. BRAYO |



1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

|               |       |       |        |                            |                 |                                         |               |       |  |
|---------------|-------|-------|--------|----------------------------|-----------------|-----------------------------------------|---------------|-------|--|
| 1             |       |       |        | 8                          | 646.9813        | LOWER DEFLECTOR LOW                     |               |       |  |
|               | 1     |       |        | 7                          | 646.9812        | LOWER DEFLECTOR HIGH                    |               |       |  |
|               |       | 1     |        | 6                          | 646.9811        | UPPER CUTTER DEFLECTOR                  |               |       |  |
| A/R           | A/R   | A/R   | A      | 5                          | 601.2045        | RTV, LOCUTITE 598                       |               |       |  |
| 3             | 3     | 3     | 4      | 601.1541                   | LOCKNUT         |                                         | M521042L08    |       |  |
| 3             | 3     | 3     | 3      | 601.2765                   | SCREW           |                                         | M527039-0819  |       |  |
| 6             | 6     | 6     | 2      | 601.2764                   | WASHER          |                                         | 14X111494833P |       |  |
| 1             | 1     | 1     | 1      | 646.9701                   | CUTTER SUB ASSY |                                         |               |       |  |
|               |       |       |        |                            | 646.9603        | LOWER CUTTER ASSY LOW                   |               |       |  |
|               |       |       |        |                            | 646.9602        | LOWER CUTTER ASSY HIGH                  |               |       |  |
|               |       |       |        |                            | 646.9601        | UPPER CUTTER ASSY                       |               |       |  |
| .9603         | .9602 | .9601 | FIND # | DATE                       | PART #          | DESCRIPTION                             | MAT'L         | SPEC. |  |
| QTY           |       |       |        | PARTS LIST                 |                 |                                         |               |       |  |
| NEXT ASSY (5) |       |       |        | ORIGINAL DATE              |                 | CAPSULE INDUSTRIES                      |               |       |  |
| 646.9500      |       |       |        | INSTRUMENT                 |                 | 2608 TEMPLE HEIGHTS DR.                 |               |       |  |
|               |       |       |        | DRAWN BY                   |                 | OCEANSIDE, CA. 92056-3512 (760)724-5300 |               |       |  |
|               |       |       |        | CHECKED BY                 |                 | CUTTER ASSY                             |               |       |  |
|               |       |       |        | APPROVAL                   |                 | SEE PAGE CODE                           |               |       |  |
|               |       |       |        | BY                         |                 | DWD INC.                                |               |       |  |
|               |       |       |        | DATE                       |                 | SCALE NONE                              |               |       |  |
|               |       |       |        | REVISION                   |                 | SHEET 1 OF 1                            |               |       |  |
|               |       |       |        | CORRECTION                 |                 |                                         |               |       |  |
|               |       |       |        | OTHERS OTHERWISE SPECIFIED |                 |                                         |               |       |  |
|               |       |       |        | TOLERANCES ARE:            |                 |                                         |               |       |  |
|               |       |       |        | 3 PLACES DECIMALS ± .01    |                 |                                         |               |       |  |
|               |       |       |        | 2 PLACES DECIMALS ± .005   |                 |                                         |               |       |  |
|               |       |       |        | ANGLES ± .5°               |                 |                                         |               |       |  |